

Work Order ID 56827

March 10, 2010 3:49:20 PM



Page 1

Item ID: D3065-041

Accept



Setup Start



Revision ID:

Item Name: Step Leg Assembly Hi

Stop



Start Date: 10/03/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: *10-3-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3065 and Identify as D3065-041

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: *CWA*

0.00



Packaging

Memo

0.00

Packaging

SAD

10-04-13

ES 10/04/13 *(30)*

control
(x30)

(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/21 *[Signature]*
mf
10-4-21

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NOTE: Date & initial all entries

Picklist Print

March 10, 2010 3:49:25 PM

Page 1

Work Order ID: 56827

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi


Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPP KJ/RF

Start Date: 10/03/2010

Required Date: 17/03/2010

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3065-1  Step Spacer		Manufactured	No			100	Each	7.0000	30.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

GA

5

53794

5

Main Warehouse

ST

2

48113

2

D3065-3



Step Spacer

Manufactured No

100

Each

23.0000

30.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

13

53800

13

Main Warehouse

ST

10

48113

10

B42344
(HX)

B53800 (13X)

B57215 (GX)

ES 10/04/12
B357214 (25K)

ES 10/04/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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March 10, 2010 3:49:25 PM

Page 2

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Parent Item Name: Step Leg Assembly Hi

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPP KJ/RF

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Required Date: 17/03/2010

Start Qty: 30.00

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3065-5		Manufactured	No			100	Each	32.0000	60.0000			
---------	--	--------------	----	--	--	-----	------	---------	---------	--	--	--



Step Leg

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

53796

32

32

100

Each

58.0000

30.0000



3/10/04/12
357216 (33x)

27

D3065-7

Manufactured No



Step Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

GA

52513

53797

58

9

49

100

Each

2,685.000

900.0000



3/10/04/12

9
21

MS20470AD4-4

Purchased

No



Rivet, Universal Head

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST319

111359

112314

113368

2685

88

245

2352

3/10/04/12

900

March 10, 2010 3:49:25 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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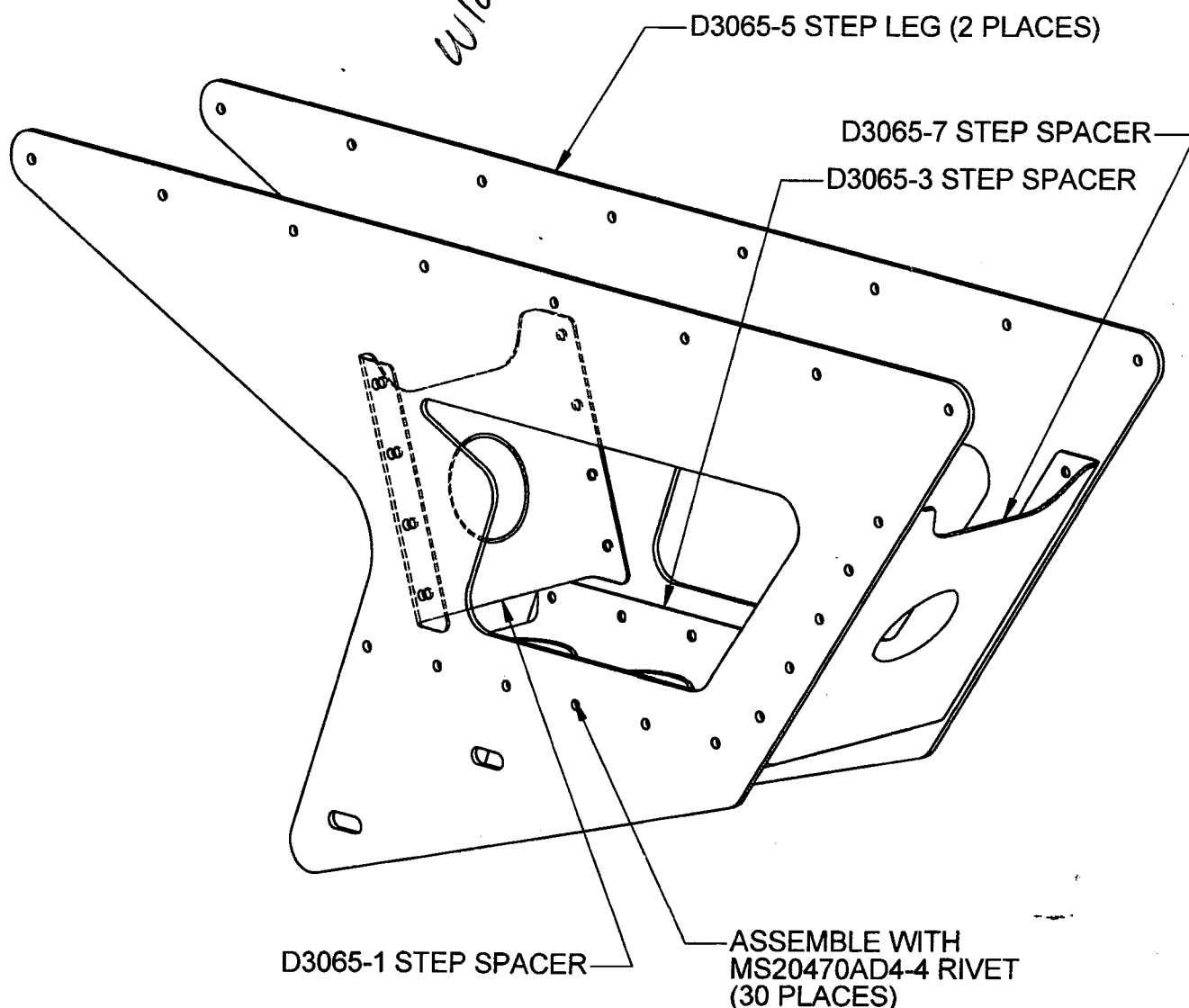


DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06-06-20 *[Signature]*

w/036827



D3065-041 STEP LEG ASSEMBLY

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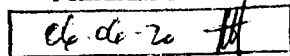
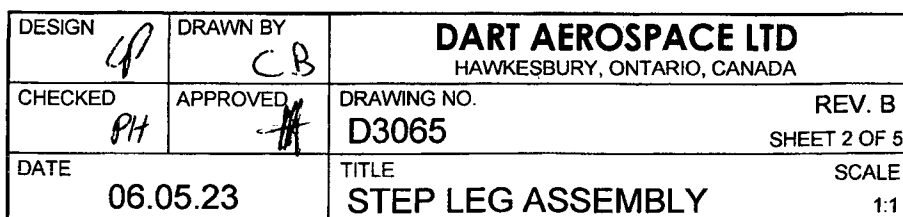
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



BEND DETAIL

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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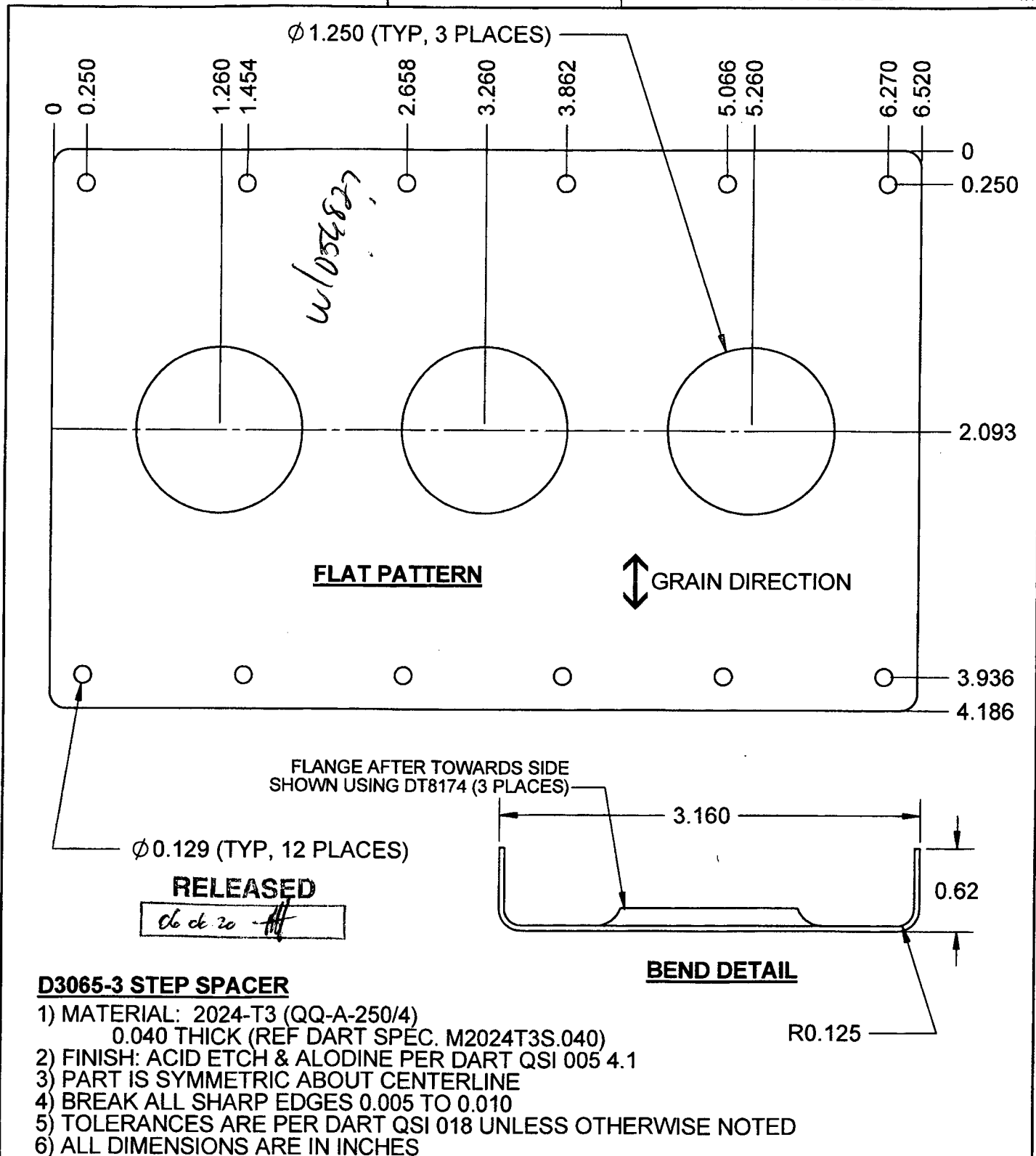
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



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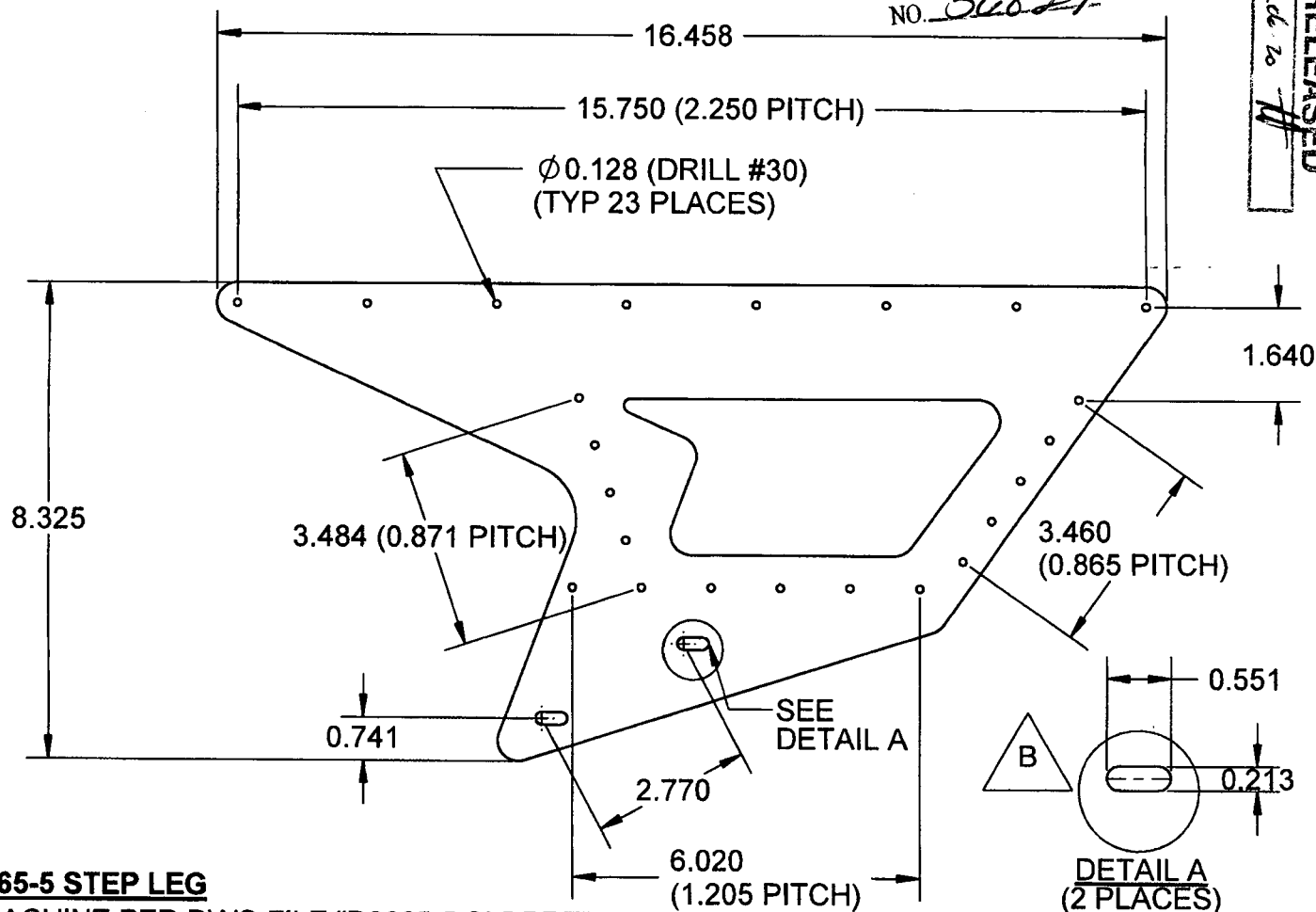
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
BT		D3065	SHEET 4 OF 5
DATE		TITLE	SCALE
06.05.23		STEP LEG ASSEMBLY	1:3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56827

RELEASED
06.06.20



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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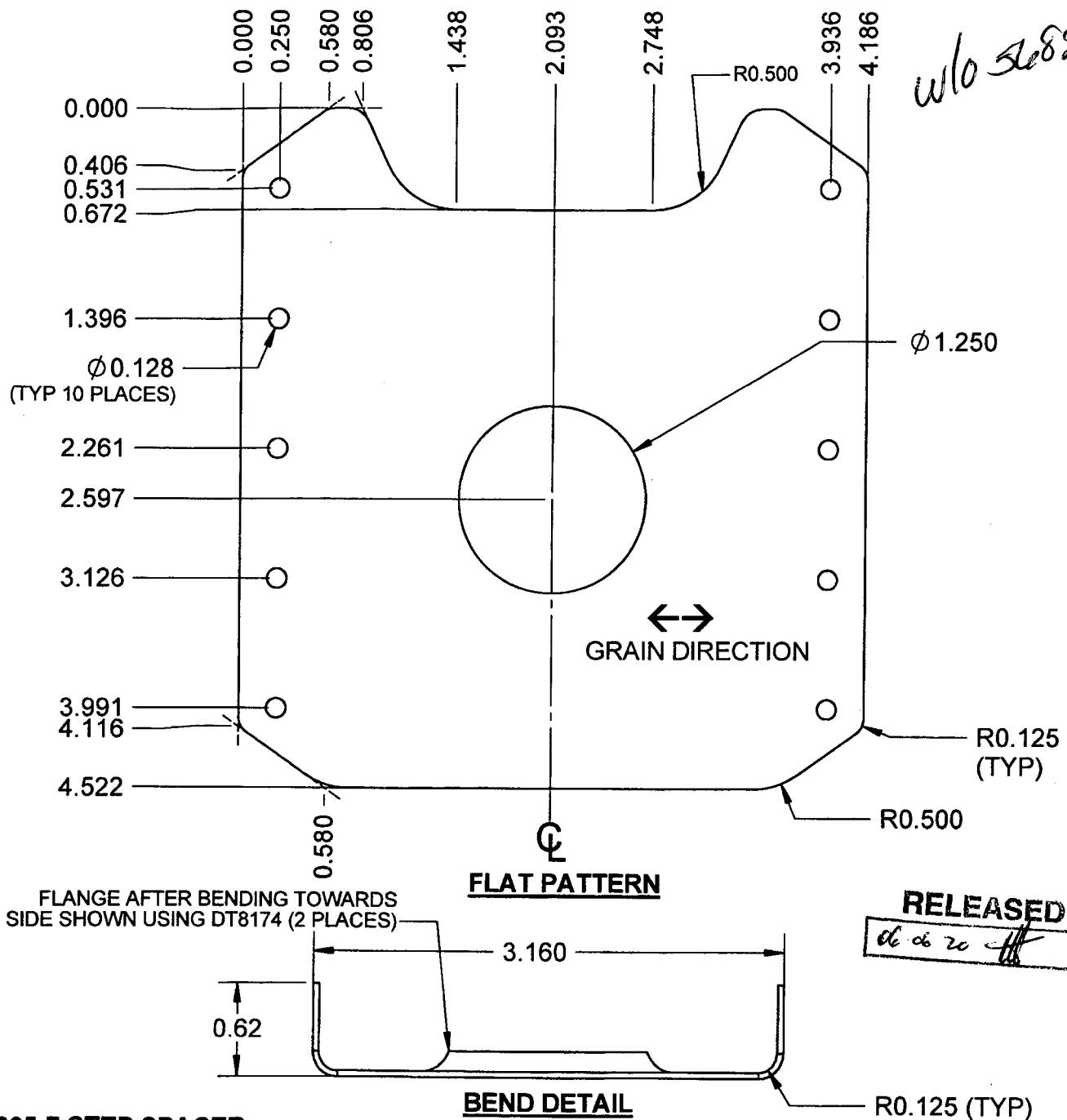
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DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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Dart Aerospace Ltd

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